

Date: Wednesday, 2/15/2006 3:50:29 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PLUG
 Job Number : 25865
 Estimate Number : 10512
 P.O. Number : N/A Part Number : D26511
 This Issue : 2/15/2006 S.O. No. : N/A Drawing Number : D2651 REV. B
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : B
 Previous Run : 25365 Material : N/A
 Due Date : 3/10/2006 Qty: 300 Um: Each
 Written By : *See Comment Below*
 Checked & Approved By : *06.02.16*
 Comment : Est: A 02.04.15 New Issue NG
 Est: B 05.12.12 added deburr EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6R0500 6061-T6 Round Bar .500"



Comment: Qty.: 0.0421 f(s)/Unit Total: 12.6315 f(s)
 Material: 6061-T6 (QQ-A-225/8) 0.500" Dia
 (M6061T6R0500)
 Batch: *M19296*

M8 06/03/05

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HAAS CNC VERTICAL MACHINING #1
 1- Turn as per Folio FA219 and Dwg D2651
 2- Deburr

M8 06/03/05

308

M8 06/03/05

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M8 06/03/05

308

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

ml 06/03/06

308

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr ias per dwg D2651

ml 06/03/08

308

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 06/07/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/15/2006 3:50:29 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 25865

Part Number: D26511

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

5A0

06:05:13

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3
(Only larger section necessary)

DL

06/07/14

308

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

IL

06 07 14

308

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: FA 15

DL

06/07/14

308

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

1A 06.07.17

Job Completion



U 06/07/17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	25865
Description: Plug		Part Number:	D2651-1
Inspection Dwg: D2651 Rev: B			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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[illegible]

Measured by: MS	Audited by: [Signature]	Prototype Approval: N/A
Date: 06/03/05	Date: 06/03/06	Date: —

Rev	Date	Change	Revised by	Approved
A	03.12.22	New Issue	KJ/RF	

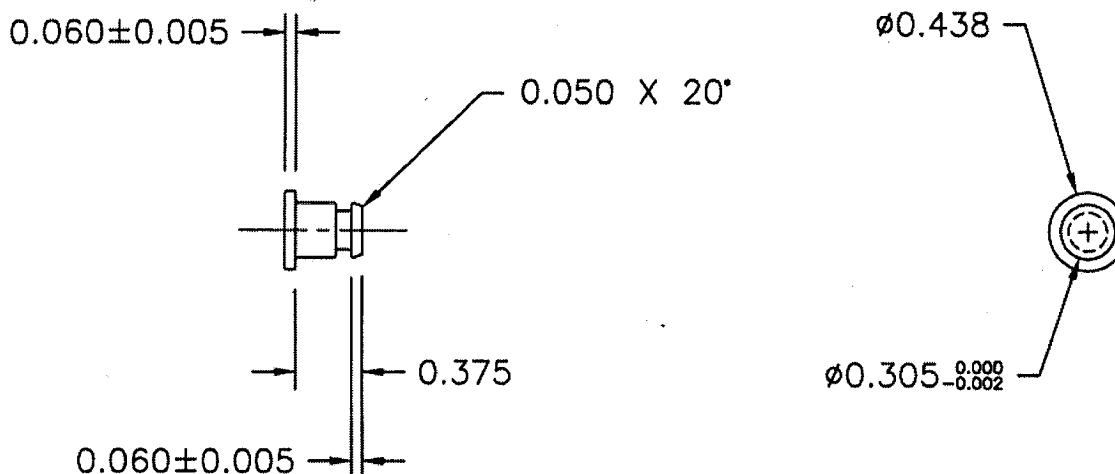


DESIGN	<i>[Signature]</i>	DRAWN BY	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2651	REV. B SHEET 1 OF 1
DATE 03.12.19			TITLE PLUG SCALE 1:1		
A	97.03.25	NEW ISSUE			
B	03.12.19	ADD POWDER COAT, MS28775-008			

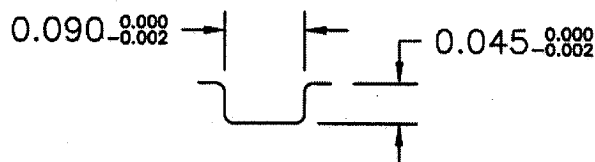
RELEASED

03.12.19 *[Signature]*

D2651-1 PLUG:



GROOVE DETAIL (SCALE 5:1)



D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER
3/16 ID, 5/16 OD, 1/16 WIDTH
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

NOTED
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 25865

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